

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004127**Date Inspected:** 03-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG Deck Panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Deck Panel	NA	NA	QAUT

Assembly Building: Caltrans Quality Assurance (QA) inspector performed the lay-out of tack welds and perform conventional ultrasonic test (UT), gate to gate inspection of the tack welds joining u-rib to deck plate. The deck panel is identified as DP434-001. The UT inspection performed by the Caltrans QA inspector was preliminary UT inspection prior to using the phased array UT system to verify indications found by the conventional ultrasonic test. Caltrans QA inspector inspected deck panel DP434-001, welds 001 and 002. Each weld consisted of eighteen (18) tack welds. Caltrans QA inspector recorded Y-locations for indications found in the weld during the UT inspection for the following:

Deck Panel DP434-001

Weld 001; Observed weld indication at Y-location, 4890 millimeter mark.

Weld 002; Observed weld indication at Y-location, 1860, 9320 and 9835 millimeter mark.

Caltrans QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Welds 003, 004, 005, 006, 007, 008, 009 and 010 for deck panel DP434-001 were not inspected during this work shift.

See Caltrans U-rib to Deck Panel-Tack Weld Assessment Record, dated 10-03-2008 for additional information.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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